

01—120 Facing cylinder crankcase parting surface

Data

Height of cylinder crankcase when new	242.8–242.9	
Minimum height following required removal of material	242.5	
Perm. unevenness of parting surface	in longitudinal direction	0.08
	in transverse direction	0.05
Perm. roughness of upper parting surface	0.006–0.016	
Perm. deviation in parallel of upper parting surface in relation to longitudinal direction	0.1	
Pressure test with air under water in bar gauge pressure (atü)	2	
Chamfer of cylinder bores	refer to note	

Note

Cylinder bores are chamfered after facing.

If the cylinder crankcase parting surface has been reconditioned, reset the timing (05—215).

